

Date: Tuesday, 29/04/2008 8:26:21 AM
 User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SLIDING DOOR BRACKET
Job Number	: 38804		
Estimate Number	: 13275		
P.O. Number	:	Part Number	: D36751
This Issue	: 29/04/2008 S.O. No. :	Drawing Number	: D3675 REVA PRELIM
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 25/04/2008 Type : SMALL /MED FAB	Drawing Revision	: A PRELIM
Previous Run	:	Material	:
Written By	: <u>Jul 08.05.25</u>	Due Date	: 02/05/2008 Qty: 12 Um: Each
Checked & Approved By	:		
Comment	: Est Rev:A new issue 08-04-21 DD verified by:EC		

Additional Product

PROTOTYPE

FOR ENGINEERING USE ONLY

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S20GA	304/316 .040 Sheet
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Comment: Qty.: 0.1271 sf(s)/Unit Total : 1.5246 sf(s)

304 stainless steel 0.032" Sheet

Batch: M107744 JB 8-4-28

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3675

Dwg Rev: A JB 8-4-28Prog Rev: A

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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JB 8-4-28

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

Jul 08.07.29(12)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

Form as per Dwg D3675

JB 08/04/29 (12)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SLIDING DOOR BRACKET

Job Number: 38804

Part Number: D36751

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

**ENGINEERING
APPROVAL**

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ASS 08.04.29 (912)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

8:50am

OVEN TEMPERATURE:

320°F

FINISH TIME:

9:20am

08.05.05

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08.05.09 (12)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

W 2006

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

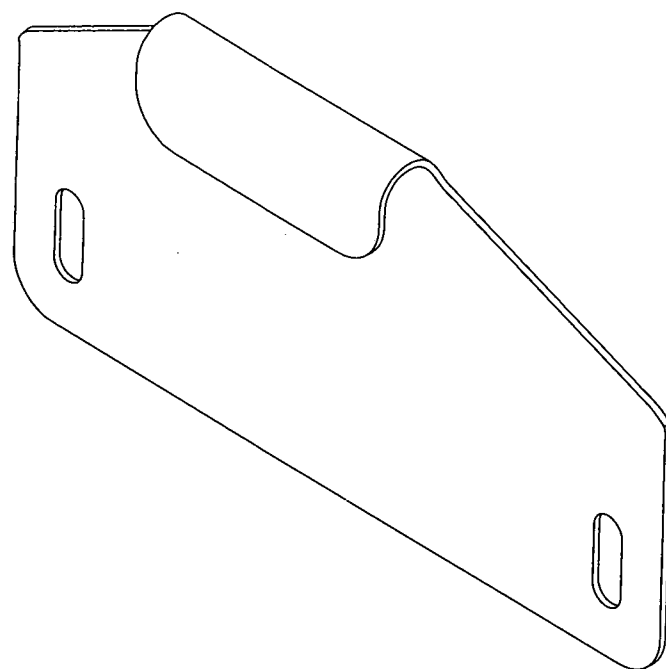
08/08/05

Job Completion



Change to w/o 00220

08.05.09



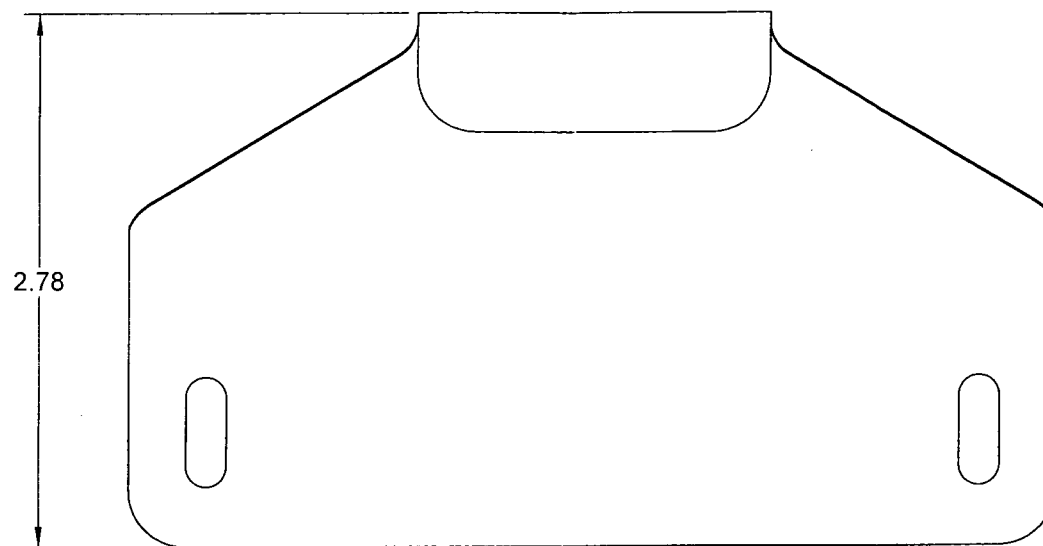
D3675-1 SLIDING DOOR BRACKET

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
AJS 08.04.17

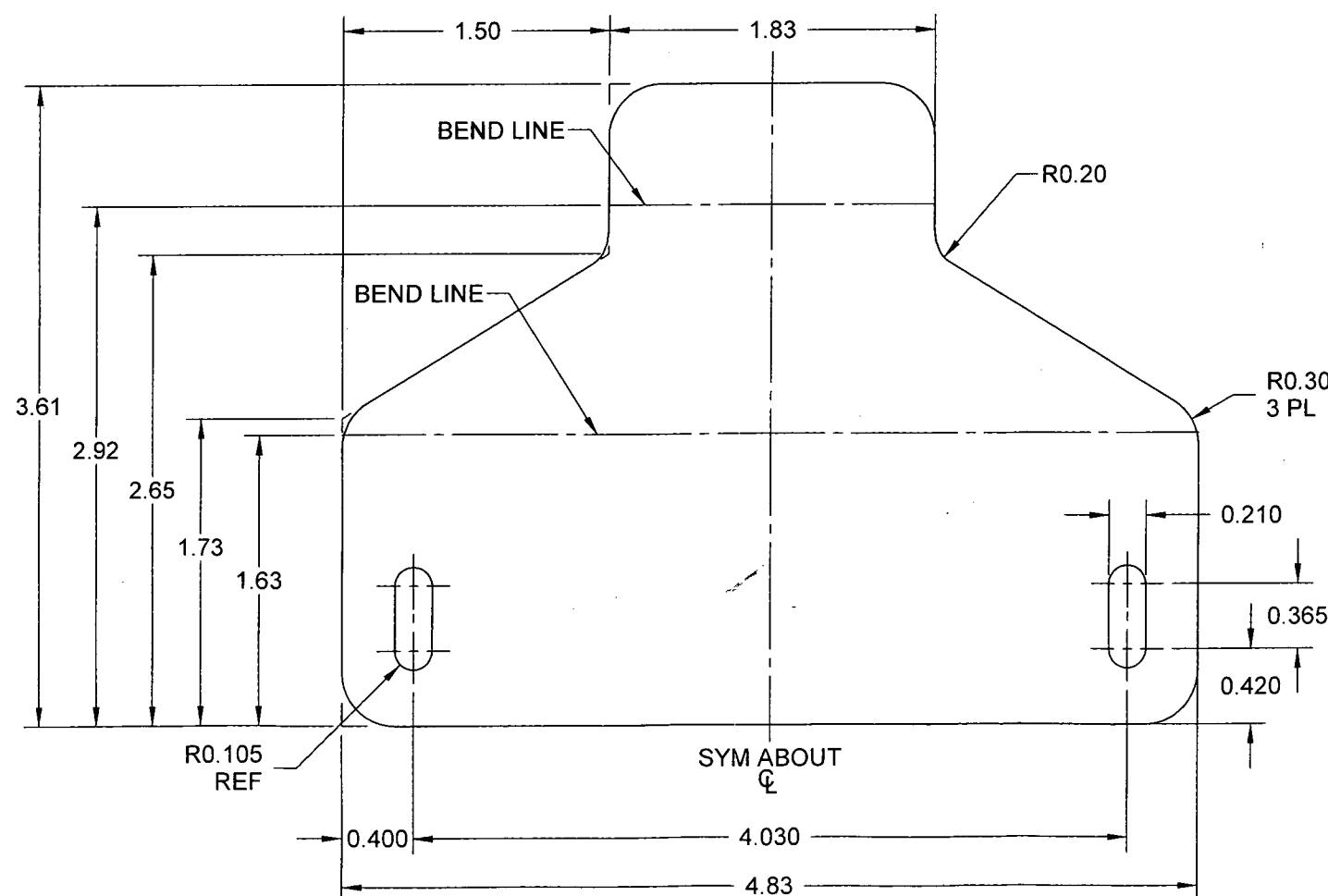
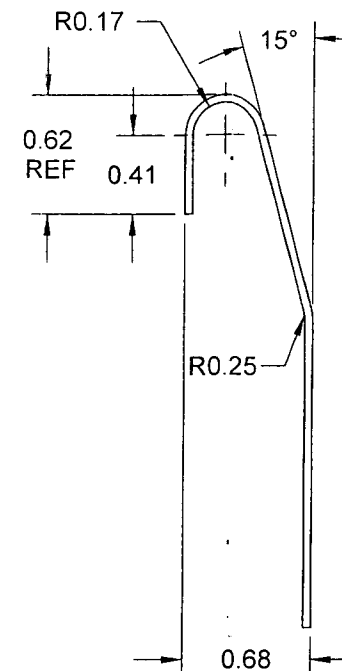
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.040 THICK
PER MIL-S-5059 (ANNEALED)
REF. DART SPEC M304S
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3675-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.15 lbs
- 8) THE D3675-1 SLIDING DOOR BRACKET IS A DERIVATIVE OF THE D3199-1 BRACKET.

A	NEW ISSUE		AJS	08.03.27
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN				
CHECKED		DRAWING NO.	REV. A	
MFG. APPR.		D3675	SHEET 1 OF 2	
APPROVED		TITLE	SLIDING DOOR BRACKET	
DE APPR.				
DATE				



D3675-1 SLIDING DOOR BRACKET
(MAKE FROM D3675-1F)



D3675-1F FLAT PATTERN

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
1508.24.17

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3675	SHEET 2 OF 2
APPROVED		TITLE	SLIDING DOOR BRACKET
DE APPR.		(COMPOSITE DOOR)	SCALE
DATE	08.03.27		NTS
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